Date:

Friday, 5/25/2007 8:01:41 AM

User

Kim Johnston

**Process Sheet** 

Customer Job Number : CU-DAR001 Dart Helicopters Services

>: 32551

**Estimate Number** 

: 10104

P.O. Number

:NIA

This Issue

: 5/25/2007

: MA

: 29883

: NC

Type

S.O. No. : NA

Part Number **Drawing Number** 

**Drawing Name** 

: D2012107

: CLEVIS

· D2012-107 REV. C

Project Number **Drawing Revision** 

: N/A : C

Material

**Due Date** 

: NIA : 6/6/2007

Qty:

50 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By Comment

: Est: D 01/11

Re-format, Drawing to Rev. C SM

: SMALL /MED FAB

Est Rev:E Now on Waterjet 06-06-13 JLM

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S16GA

304/316 .063 Sheet



Comment: Qty.:

0.0146 sf(s)/Unit

Total:

0.7298 sf(s)

304/316 .063 Sheet

(M304S063)

Batch: MI 0396

2.0

WATER JET



FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2012-107 Dwg Rev: C

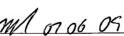
Prog Rev:

m 0106 09

2-Deburr if necessary

3.0

QC2



INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK



Comment: SECOND CHECK

-QC8



5.0

BRAKE NO

NC BRAKE



KSO

Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-107

<b>Dart</b>	<b>Aeros</b>	pace	Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
				_						

Part No:	**	_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 07/06/29
				QA: N/C Closed:	Date:

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section 6	3	Verification	Annuaral	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
	V <sub>1</sub>							
			*					

NOTE: Date & initial all entries

Friday, 5/25/2007 8:01:41 AM Date: Ûser: Kim Johnston **Process Sheet** Drawing Name: CLEVIS Customer: CU-DAR001 Dart Helicopters Services Job Number: 32551 Part Number: D2012107 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock

8.0 QC21

Job Completion

Location:

Comment: FINAL INSPECTION/W/O RELEASE

(L07/06/29

207/26/29

## **Dart Aerospace Ltd**

W/O:			WORK OR	DER CHANG	ES				
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
			*						
				:					
								*	
Part No	:	PAR #:	Fault Category:		_ NCR: Yes	No I	DQA:	_ Date: _	
					QA: I	N/C Clo	sed:	_ Date: _	
NCD.			WORK ORDER NON	LCONFORMA	NCE (NCI	5)			

	WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action Section B			Annroval	Annroyal	
STEP	Section A		Chief Eng	Approval QC Inspector				
	+							
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Proval Initial Action Description Sign & Section C Chief Eng	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32551
Description: Clevis	Part Number:	D2012-107
Inspection Dwg: D2012 Rev: C		Page 1 of 1

	FIR	ST ARTICLE	INSPEC	TION CHI	ECKLIST		
		X First A	rticle [	Prot	otype		
Drawing	Tolerance	Actual	Accept	Reject	Method of	Com	ıments
Dimension		Dimension		•	Inspection		
0.380	+/-0.010	0.318	$\sqrt{}$		new		
1.325	+/-0.010	1.323			ver		
2.649	+/-0.010	2.649	$\checkmark$		vern		
0.380	+/-0.010	0:378	$\sqrt{}$		vern		
0.750	+/-0.010	0.754	$\sqrt{}$		Vers		
R0.354	+/-0.010	RO. 354	$\checkmark$		VERN		
Ø0.257	+0.006/-0.001	0.257			vern		
0.063	+/-0.010	0.059	V		vern		
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Measured by:	m.nl	Audited b	y: 6	/	Prototype App	oroval:	N/A
Date:	07 06 09	Dat	e: Oro	16.12		Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.02.02	New Issue	KJ/JLM 🚓	all
		,		7~/

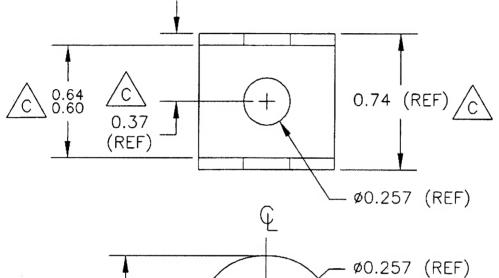


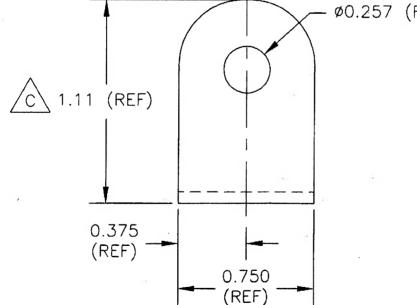


	DESIGN B	W	PF		AEROSPACE LTD KESBURY, ONTARIO, CANADA		
)	CHECK	<b>S</b> 9	APPROVED	DRAWING NO.		REV.	C
	9	The state of the s	#	D2012-107	SHEET	1 OF	2
	DATE			TITLE		SCAL	ĿΕ
	99.1	2.20	·	CLEVIS		2	2:1
	Α		94.10.27	NEW ISSUE			

RELEASED

99.1	2.20	CLEVIS	 2:1
Α	94.10.27	NEW ISSUE	
В	99.04.30	ADD FLAT PATTERN	
С	99.12.20	0.74 WAS 0.680	





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WITHOUT NOTICE

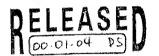
MATERIAL: AISI 304/316 SS 0.063 THICK

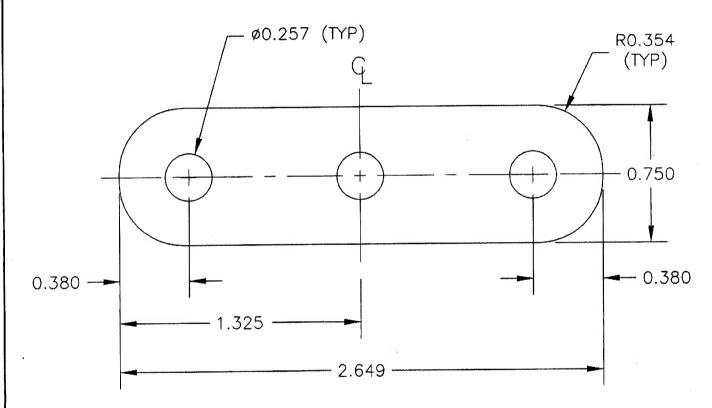
USE 0.032 BEND RADIUS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES



DESIGN BW	ORAWN BY	DART AEROSP HAWKESBURY, ONTARI	
CHECKED,	APPROVED H	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATE.		TITLE	SCALE
99.12.20		CLEVIS	2:1





D2012-107 FLAT PATTERN

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WORK ORDER

WORK ORDER NO. 3255

MATERIAL: AISI 304/316 SS 0.063 THICK TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES